

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEM
Job Number	: 34648		
Estimate Number	: 10857		
P.O. Number	: N/A	Part Number	: D34073
This Issue	: 9/12/2007 S.O. No. : N/A	Drawing Number	: D3407 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 33431	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 9/30/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	20 Um: Each
Comment	: Est Rev: A 05.10.18 New issue KJ/EC		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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2	1000	1000
3	1000	1000
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98	1000	1000
99	1000	1000
100	1000	1000

10	M174R0750	Inventory
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Comment: Qty.: 0.3843 f(s)/Unit Total : 7.6860 f(s)
Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)
Identify for D3407-3
Batch: *M 104965* *20 of 129*

NOT ENOUGH MATL.

20 HARDINGE HARDINGE/CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA597 Rev: C & Dwg D3407 Rev: C

2-Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 HAAS1 HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/05/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:17:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 34648

Part Number: D34073

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

U 07-09-18 9

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

U 07-09-18 9

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *welding*

U 07-09-18 9

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U 07-09-19 9

Job Completion



U 07-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34648
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407 Rev: C		Page 1 of 1	

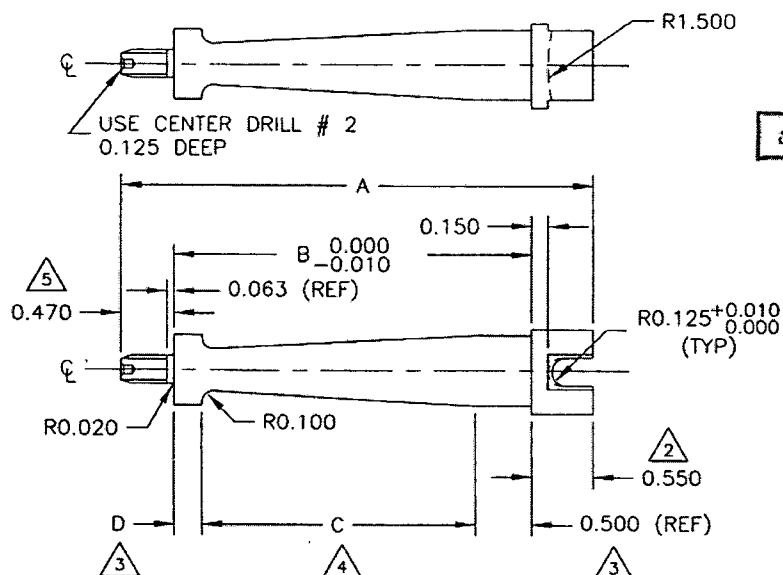
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.325	+/-0.010	4.322	✓			
3.305	+0.000/-0.010	3.228	✓			
2.555	+/-0.010	2.550	✓			
0.250	+/-0.010	.254	✓			
0.063	+/-0.010	.063	✓			
0.470	+/-0.010	.471	✓			
0.500	+/-0.010	.500	✓			
0.550	+/-0.010	.550	✓			
Ø0.625	+0.008/-0.004	.619	✓			
Ø0.750	+0.008/-0.004	.749	✓			
Ø0.363	+0.006/-0.001	.360	✓			
0.250	+0.010/-0.000	0.250	✓			
0.625	+/-0.010	.624	✓			
0.150	+/-0.010	0.149	✓			
R0.125	+0.010/-0.000	R0.125	✓			
1/4-28 UNF	N/A	✓	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07/09/18	Date: 07-09-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

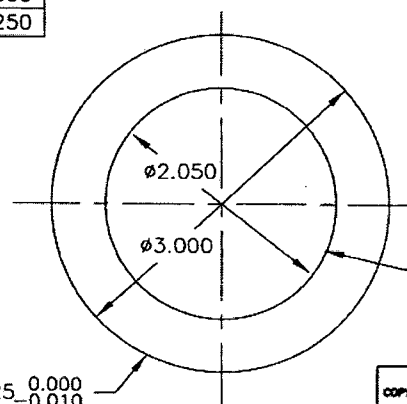
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

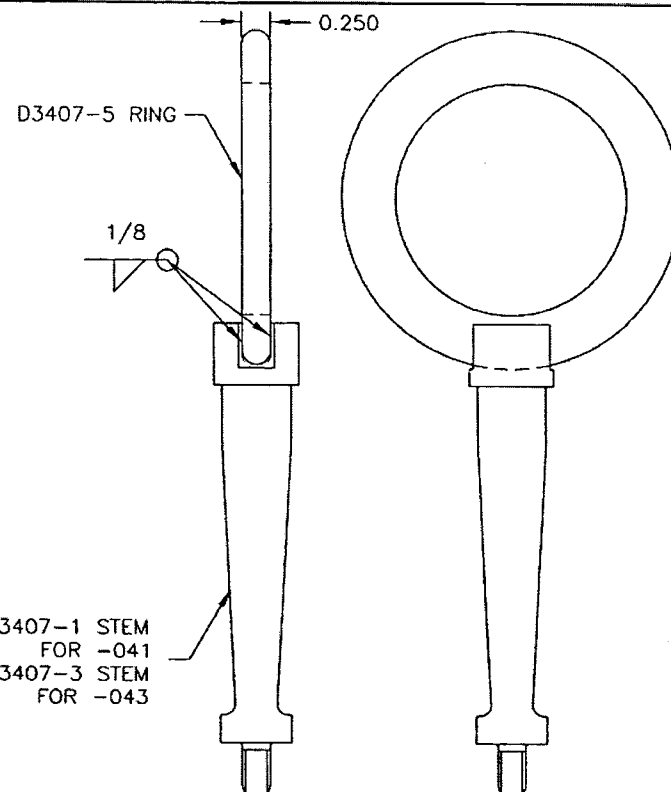
- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING

RELEASED

05 09.12



USE D3407-1 STEM
FOR -041
USE D3407-3 STEM
FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DART AEROSPACE USA, INC.
CHECKED	CP	PORT HAVEN, VA
APPROVED	CP	DART AEROSPACE USA, INC.
DRAWING NO.	D3407	REV. C
DATE	05.09.09	SHEET 1 OF 1
TITLE	TOW RING	SCALE 1:1

NO. 34648
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
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ENGINEERING
RETURN TO
SHOP COPY